DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES Office of Structural Materials

Quality Assurance and Source Inspection

Bay Area Branch 690 Walnut Ave.St. 150 Vallejo, CA 94592-1133 (707) 649-5453 (707) 649-5493



Contract #: 04-0120F4

Cty: SF/ALA Rte: 80 PM: 13.2/13.9

File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Pursell, Gary **Report No:** WIR-015509 Address: 333 Burma Road **Date Inspected:** 07-Jul-2010

City: Oakland, CA 94607

OSM Arrival Time: 700 **Project Name:** SAS Superstructure **OSM Departure Time:** 1900 **Prime Contractor:** American Bridge/Fluor Enterprises, a JV

Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name: Mr. Huang min / Mr. Chen Xi **CWI Present:** Yes No **Inspected CWI report:** Yes N/A **Rod Oven in Use:** Yes No No N/A Yes N/A **Electrode to specification:** No Weld Procedures Followed: Yes No N/A N/A **Qualified Welders:** Yes No **Verified Joint Fit-up:** Yes No N/A N/A Yes N/A **Approved Drawings:** Yes No **Approved WPS:** No Yes No N/A **Delayed / Cancelled:**

34-0006 **Bridge No: Component:** Orthotropic Box Girder (OBG)

Summary of Items Observed:

This CALTRANS OSM Quality Assurance Inspector (QA) Surendra Prabhu was present during the times noted above for observations relative to the fabrication of the Self Anchored Suspension (SAS) Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA observed and/or found the following:

BAY-3

Submerged Arc Welding (SAW) of weld joint LD3025-001-004. Welder is identified as 053748. ZPMC Quality Control (QC) is identified as Mr. Zhang Yaxu. The welding variables appeared to comply with the Applicable WPS: WPS-B- T-2221-B-L2c-S-2. Refer the attached photo for reference.

BAY-6

The following Non Destructive Testing (NDT) Inspection carried out as per the ZPMC submitted Notification No. 06143.

Magnetic Particle Testing (MT)

This QA performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA generated MT report for this date. The members are identified as OBG Bottom Panel weld Component. MT performed on weld repaired area. Total number of welds MT Tested: 01 No. The

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

weld designations are review as follows:

1. BP3044-001-028.

Signed off the following green tag:

1. 13283.

This QA Inspector Randomly observed the following work in progress:

Shielded Metal Arc Welding (SMAW) of weld joint WJF-0-106. Welder is identified as 215083. ZPMC Quality Control (QC) is identified as Mr. Zhao Jian Hang. The welding variables appeared to comply with the Applicable WPS: WPS-B- P-2112.

Submerged Arc Welding (SAW) of weld joint WJF-0-188. Welder is identified as 053748. ZPMC Quality Control (QC) is identified as Mr. Zhao Jian Hang. The welding variables appeared to comply with the Applicable WPS: WPS-B- T-3221-TC-U4a-S-1.

ZPMC QC Certified Welding Inspector Mr. Huang min was performing Visual Testing for the welds located on Bottom Panel identified as BP3066-001. Refer attached photos for additional details.

BAY-7

SMAW Tack welding of weld joint EP3013-001-009/010. Welder is identified as 049485. ZPMC Quality Control (QC) is identified as Mr. Cui jun jie. The welding variables appeared to comply with the Applicable WPS: WPS-B- P-2112.

Flux Cored Arc Welding (FCAW) of weld joint BP3038-001-001/002. Welder is identified as 053609. ZPMC Quality Control (QC) is identified as Mr. Wang Liang. The welding variables appeared to comply with the Applicable WPS: WPS-B- T-2132-3.

FCAW of weld joint BP3038-001-005/006. Welder is identified as 204342. ZPMC Quality Control (QC) is identified as Mr. Wang Liang. The welding variables appeared to comply with the Applicable WPS: WPS-B-T-2132-3.

FCAW of weld joint BP3038-001-009/010. Welder is identified as 217185. ZPMC Quality Control (QC) is identified as Mr. Wang Liang. The welding variables appeared to comply with the Applicable WPS: WPS-B-T-2132-3.

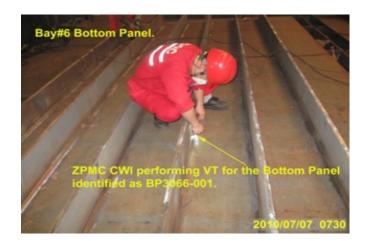
ZPMC Personnel performing Heat Straightening for the Bottom BP3058A. Heat straightening was being performed appeared to comply with the Applicable HSR Repot# HSR1 (B)-8730 .ZPMC Quality Control (QC) is identified as Mr. Xia Yong Zheng.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

documents.





Summary of Conversations:

Only general conversation was held between QA and Quality Control (QC) concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Prabhu,Surendra	Quality Assurance Inspector
Reviewed By:	Hall,Steven	QA Reviewer